

Monday, 18/08/2008 3:44:26 PM
Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FWD ADJUSTABLE BLADE SUPPORT ASSY
Job Number :	41365		
Estimate Number :	13435		
P.O. Number :		Part Number :	PB674300111
This Issue :	18/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.8
First Issue :	/ /	Project Number :	N/A
Previous Run :	40606	Drawing Revision :	B1
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	18/09/2008
Written By :		Qty:	8 Um: Each
Checked & Approved By :	<i>JL 08.08.18</i>		
Comment :	Est Rev:A 08-06-26 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001247	Inner Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Inner Tube

batch: *41491*

JL 08.09.27

2.0	PB6743001249	Inner Tube Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Inner Tube Bushing

batch: *M18144*

JL 08.09.27

3.0	PB6743001253	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Gusset

batch: *340717 41492*

JL 08.09.27

4.0	PB6743001254	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Gusset

batch: *340053 41493*

JL 08.09.27

5.0	PB674300167	PB67-43001-67
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

PB67-43001-67

batch: *41214*

JL 08.09.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:44:26 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 41365

Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

JE 08.09.29 2

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PL 08.09.29

JE 08.09.29

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08.09.29 (42)

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

HELICAL INSERT

M17935

JE 08.09.29

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- install helicol insert as per dwg

JE 08.09.29

JE 08.09.29

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08.09.29 (42)

12.0

HAND FINISHING1

HAND-FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

1/4 S 08.09.30

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M-P 08/09/30

(2X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 41365

Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00
320 OF
9:30

M-L

08/09/30

(2X)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



gls



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-30

(2)

15.0

PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

90 Degree Cover Plate

batch: 41511

x 4

Cpl 08-10-22

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

PB67-43001-83

batch: ~~B40096~~ x 4

x 4

41516
~~B41516~~ x 4

Cpl 08-10-22

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

Screw

batch: m109031

x

Cpl 08-10-22

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

WASHER

batch: m109031

Cpl 08-10-22

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

M-L / Cpl 08-10-22

(X4)

(72)

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/23

(X2)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Cont welding

08/10/23

(X2)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/23

Job Completion



MF 08-10-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 41305
 WORK ORDER
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
 UNCONTROLLED COPY
 RETURN TO
 ENGINEERING
 SHOP COPY

